

Work Order ID 54837

December 29, 2009 8:26:17 AM

Page 1

Item ID: D3290-041

Accept

Revision ID:

Item Name: Replacement Window Assembly

Start Date: 12/30/2009 Start Qty: 6.00

Required Date: 1/13/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *09-12-29* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3290

DEO Rev C1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3290 (use prog. for D3290-1)

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

NOT NOT pulled

B 10-1-8



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-1-8

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 810601/08



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-01-11

(7)

Memo

0.00

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

11/13/10

BR 10-01-12

(X7)

Memo

0.00

START TIME: 11:05AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 1:05AM

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

BR 10-01-12

(7) ✓

Memo

0.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00



Small Fab

Small Fab

Memo

0.00

SAN

10-02-02

7

Pto ->

Small Fab

Assemble as per Dwg D3290
Clean D3290-041 and place in plastic wrap

170

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

=> 8/10/12/12

7

Quality Control

180

0.00



Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

39

10-2-3

7

Packaging

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: D3290-041 PAR #: _____ Fault Category: Thermoforming NCR: (Yes) No DQA: [Signature] Date: 10/02/10
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/02/11

| NCR: 54837 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| 10/2/12 | #160 | Found at Assembly window D3290-3 B# 53897 is warped & bent R.C: Thermoforming drapping/process | [Signature] 10/5/12 | -Scrap & Destroy ADD replace from stores D3290-3 | [Signature] 10-02-12 | [Signature] 10/02/12 | [Signature] 10/5/12 | [Signature] 10/02/12 |
| | | | [Signature] 10/5/12 | → no more D3290-3 B# 53897 in stock | [Signature] 10/02/12 | | [Signature] 10/5/12 | [Signature] 10/02/12 |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 54837

December 29, 2009 8:26:17 AM



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Item ID: D3290-041

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Setup Start



Revision ID:

Item Name: Replacement Window Assembly

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Start Date: 12/30/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 1/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/03 *[Signature]*
MF
10-2-3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December 29, 2009 8:26:16 AM

Page 1

Work Order ID: 54837



Parent Item: D3290-041

Parent Item Name: Replacement Window Assembly

Start Date: 12/30/2009

Required Date: 1/13/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6S.063 | | Purchased | No | | | 100 | sf | 55.7377 | 23.6842 | | | |
| | | | | | | | | | | | | |
| 6061-T6 .063 Sheet | | | | | | | | | | | | |

BIG-1-2

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

55.7372105

110551

29.6341211

112939

26.1036

112939

D2126

Manufactured

No

160

f

309.3334

39.0000

SAD

10-01-03

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

309.3334

48285

309.3334

39.000

(D2126-0780) cut qty (1) at 78.00" as per dwg

per kit

D3290-3

Manufactured

No

160

Each

3.0000

6.0000

SAD

10-01-03

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

3

47693

3

3

53897

55046

→

1

→

4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

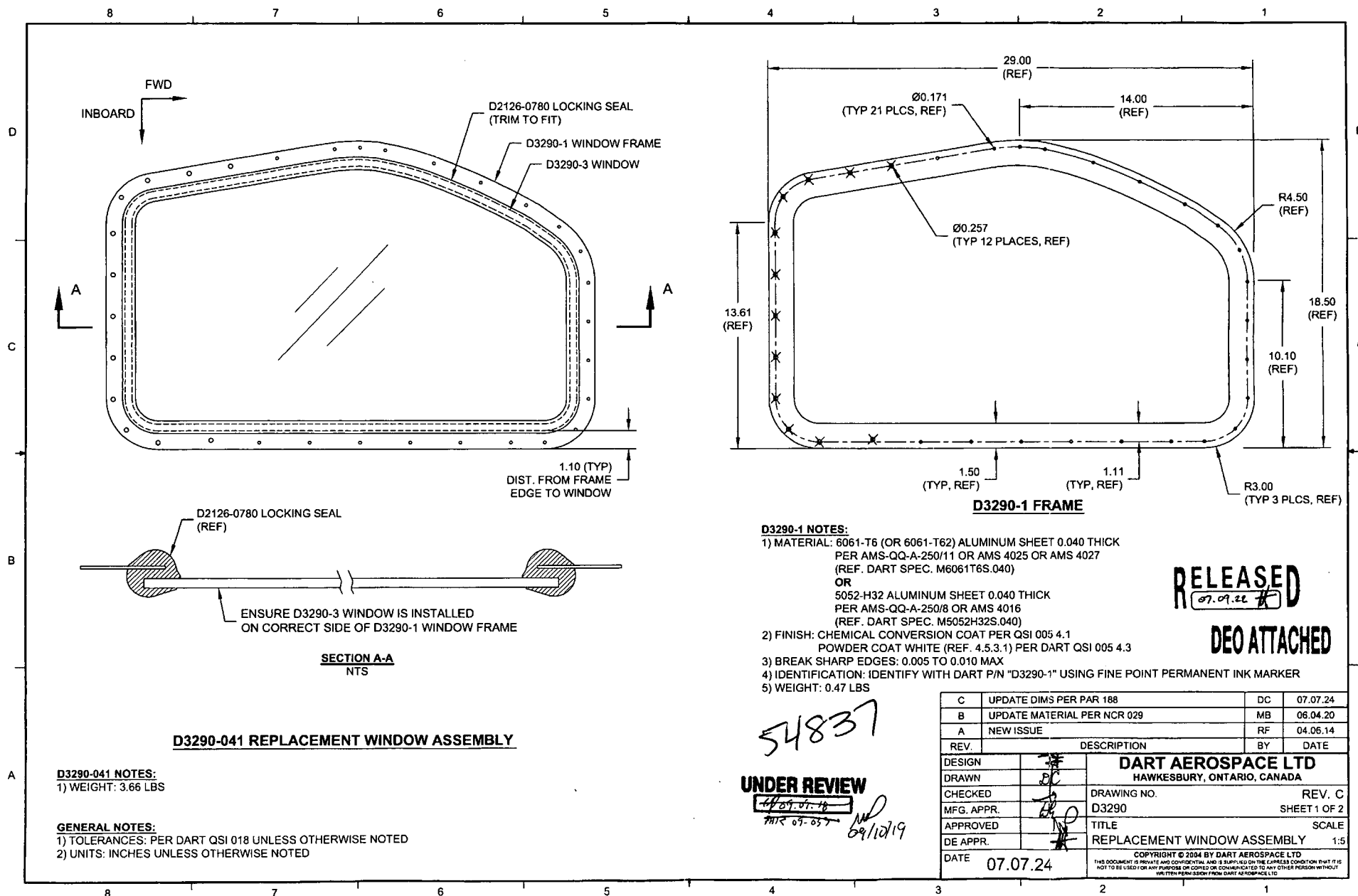
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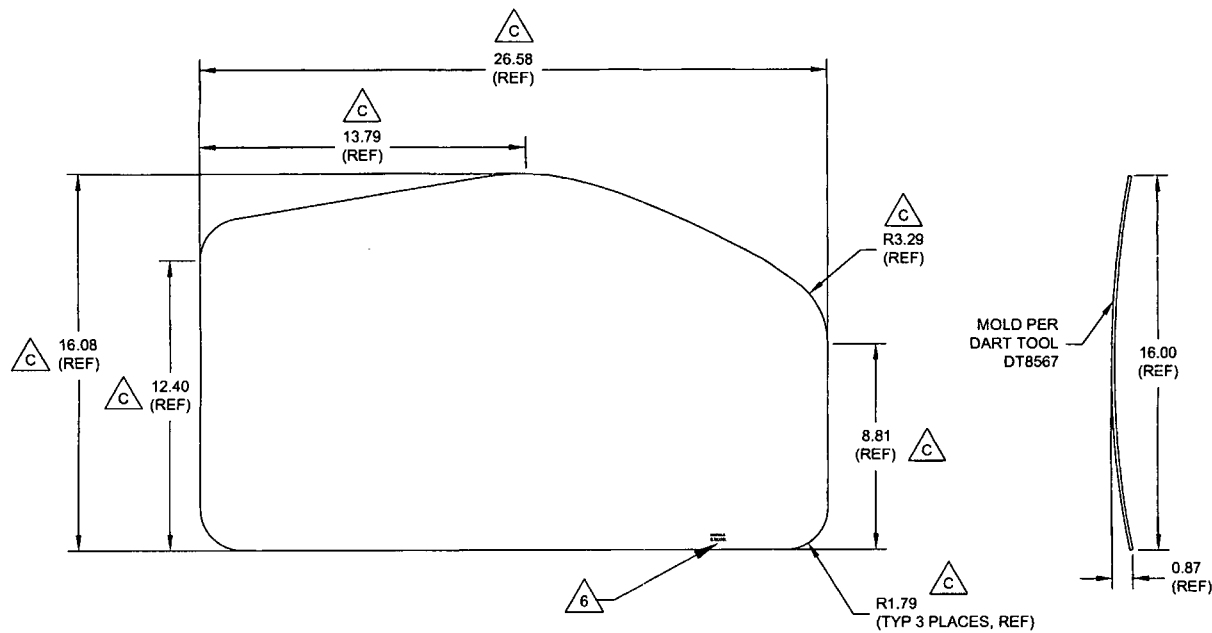
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NOTE: Date & initial all entries



D3290-3 WINDOW



D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

UNDER REVIEW

DEO ATTACHED
RELEASED

| | | | |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|--------------|
| DESIGN | 3F | DART AEROSPACE LTD | |
| DRAWN | JE | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JE | DRAWING NO. | REV. C |
| MFG. APPR. | JE | D3290 | SHEET 2 OF 2 |
| APPROVED | JE | TITLE | SCALE |
| DE APPR. | JE | REPLACEMENT WINDOW ASSEMBLY | 1:5 |
| DATE | 07.07.24 | COPYRIGHT © 2004 BY DART AEROSPACE LTD | |
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| | | | | | | | |
|----------------------|--------------------------------------|----------------------|-----------------------------------------|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D3290 | TITLE REPLACEMENT WINDOW ASSEMBLY | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3290-C-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>qp</i> | CHECKED <i>ls</i> | MFG. APPR. <i>EZ</i> | APPROVED <i>WJ</i> | | DE APPR. <i>##</i> | | |
| DATE 09.09.18 | DATE 09.09.18 | DATE 09.09.18 | DATE 09/09/21 | | DATE 09/09/21 | | |

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009 -10- 09
WJ

54837

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